

Date: Tuesday, 11/29/2005 7:13:14 PM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BLADE FITTING
Job Number :	25051		
Estimate Number :	10020		
P.O. Number :		Part Number :	D27422
This Issue :	11/29/2005	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2742 REV B
First Issue :	1 / 1	Project Number :	N/A
Previous Run :		Drawing Revision :	B
	Type :	Material :	
	MACHINED PARTS	Due Date :	12/26/2005
Written By :		Qty:	12 Um: Each
Checked & Approved By :			
Comment :	Created By Auto Work Order		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6103001	7075-T651 3.25OD x 12.5L
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)
 7075-T651 3.25OD x 12.5L
 (D6103-001 BLANK)
 Batch : _____

Tools:

2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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Comment: MORI SEIKI CNC LATHE LARGE
 TURN AS PER FOLIO FA099 & DSK050
 FOLIO REV: _____
 DWG REV: _____

Tools:

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Tools:

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 1-MACHINE AS PER FOLIO FA099 & DWG D2742
 FOLIO REV: _____
 DWG REV: _____

2-DEBURR & TUMBLE

Tools:

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/29/2005 7:13:14 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE FITTING

Job Number: 25051

Part Number: D27422

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Tools:

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

Tools:

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Chemical Conversion Coat as per QSI 005 4.1

2-Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3

Tools:

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Tools:

9.0

ALS41032225

Insert



Comment: Qty.: 4.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
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4	ALS4-1032-225	Insert	
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or AKS4-1032-225

or ALS7-1032-225

or AKS7-1032-225

Tools:

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install ALS4-1032-225 Insert as per Dwg D2742

Tools:

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 25051

Part Number: D27422

Job Number: 

Seq. #:	Machine Or Operation:	Description :
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11.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

Tools:

12.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL
Inspection Level 21

Tools:

Job Completion 

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	
Description: Blade Fitting	Part Number:	D2742-2
Inspection Dwg: D2742 Rev: B1; DSK050 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

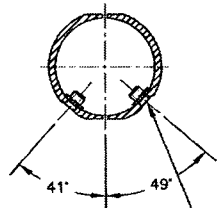
☒ **First Article**
☐ **Prototype**

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
LATHE	8.000	+0.030/-0.000					
	9.250	+/-0.010					
	Ø3.240	+0.005/-0.000					
	Ø3.125	+0.005/-0.000					
	Ø2.780	+0.005/-0.000					
	Ø2.450	+0.005/-0.000					
	0.125 x 45°	+/-0.010					
	0.125	+/-0.010					
	12.50	+0.030/-0.000					
HAAS	0.100 x 0.135	N/A	N/A				
	0.500	+0.005/-0.000					
	1.500	+/-0.005					
	11.46	+/-0.030					
	1.180	+/-0.005					
	3.150	+/-0.005					
	3.500	+/-0.005					
	Ø0.484	+0.005/-0.000					
	Ø0.508	+0.005/-0.000					
	1.000	+/-0.010					
	0.926	+/-0.010					
	0.500	+/-0.010					
	1.230	+/-0.010					
	0.125	+/-0.010					
	2.620	+/-0.010					
	0.297	+0.005/-0.000					
	Ø0.430 x 0.045	+/-0.010					

Measured by:		Audited by:		Prototype Approval:	N/A
Date:		Date:		Date:	

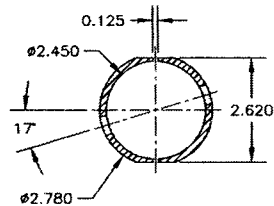
Rev	Date	Change	Revised by	Approved
A	03.12.12	New Issue	KJ/RF	

SECTION B-B



Ø0.297
C BORE Ø0.430 x 0.045"
INSTALL ALS4-1032-225 (OR AKS4-1032-225
OR ALS7-1032-225 OR AKS7-1032-225)
INSERTS AFTER FINISH
(4 PLACES)

SECTION A-A

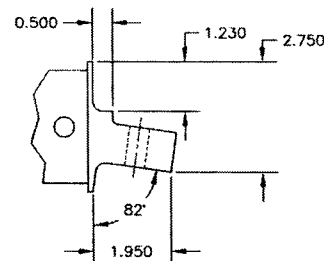


EFFECTIVE DEOs

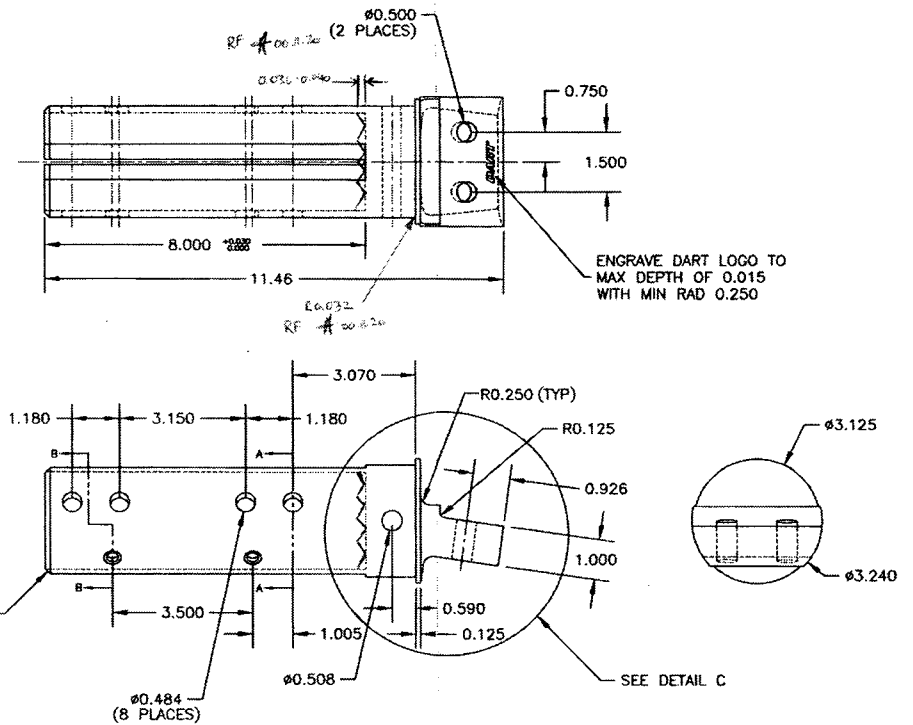
9147	
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GENERAL NOTES

MATERIAL: 7075-T651 (QQ-A-200/11 OR QQ-A-225/9)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BREAK UNMARKED SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DETAIL C



D2742-1 SHOWN (D2742-2 OPPOSITE)

RELEASED
98.11.03 DS



B	98.09.01	ADD INSERTS, AS MANUFACTURED
A	98.04.16	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. FARFIELD INTERNATIONAL AIRPORT, WA
CHECKED	APPROVED	DRAWING NO. D2742
DATE	98.09.01	SCALE 1:3